

Barrel Threading & Muzzle Brakes

Available at <http://www.dynasystems-ltd.com/>

Below is the type of barrel threading kit I use to attach muzzle brakes. They are very easy to use and worked flawlessly even the first time I tried it. **Check the laws concerning threaded barrels.**

Where I live a post ban rifle that has a threaded barrel must have a muzzle nut covering the threads or the brake must be permanently attached by welding or silver soldering. I think they look so much nicer than the pin-on brakes.

I was able to rent this kit from someone for much less than it would have cost to buy it. He can be reached at wjm@gte.net and will usually send the kit anywhere in the US. His particular kit cuts 14mm X 1 Left Hand threads. Below is a rifle sizing chart. Be sure you can find a brake that matches the threads you intend to cut.

The **Saiga** rifles have a sleeve extending from the front sight that wraps around the barrel. This is to make it more difficult to thread the barrel for a muzzle brake. Dynasystems sells adaptors to counteract this problem. I've been told that both the 7.62X39 and .223 calibers are .715 outside diameter. This would allow the use of the same adaptor on either caliber. This is the method I'd choose for a Saiga muzzle brake.

TAT



T.A.T.- Threading Alignment Tool is a device, which guides the threading die on the gun barrel in the straight direction. Threading without TAT would be a very difficult procedure probably done by the professional machinist. Our TAT is a simple tool that allows anybody to thread a gun in short time without an experience and need to take the gun apart. TAT is the

specialized tool and has to be custom made for each barrel size and caliber. However we stock TATs for most common sizes.

THREAD SIZE	CALIBER		PRICE
TAT 14x1 LH	7.62	stocking	\$12.95
TAT 14x1 RH	7.62	stocking	\$12.95
TAT 14x1 RH	6	custom	\$29.95
TAT 1/2x28 RH	0.223	stocking	\$12.95
TAT 9/16x24 LH	308	custom	\$29.95
TAT 9/16x24 RH	308	custom	\$29.95



HANDLE is a tool that holds Threading Die with three setscrews and allows you to turn the die in the cutting direction easier.

HANDLE SIZE	PRICE
1 "	\$7.95
1 1/2"	\$11.95
2"	\$18.95



KIT

THREADING KIT is what you need for threading your barrel. Parts of the Kit are TAT, DIE and HANDLE. This kit comes with the detailed instruction sheet. You can also purchase 4oz bottle of special cutting oil (not part of the kit). We stock standard kits for most common guns as AK-47, SKS, AR-15 or

MAK-90. When you are ordering please specify SIZE OF THE BARREL and CALIBER.

KIT TYPE	CALIBER		PRICE
14x1 LH	7.62	stocking	\$59.95
14x1 RH	7.62	stocking	\$44.95
1/2x28 RH	0.223	stocking	\$44.95
9/16x24 LH	308	custom	\$65.95
9/16x24 RH	308	custom	\$54.95

4oz of Threading Oil \$2.95



Threading Instructions



ORIGINAL THREAD SIZES

RIFLE	CALIBER	THREAD SIZE
AR-15, M-16, AR-180	.223 (5.56mm)	1/2x28
AR-15, M-16, AR-180	9mm	1/2x36
Ruger Mini 14 (blue)	.223 (5.56mm)	9/16x24
Ruger Mini (stainless)	.223 (5.56mm)	9/16x24

Ruger Mini 30 (blue, stl)	7.62x39	5/8x24
HK-91/ G-3	308/ 7.62	15x1
HK-93/ 33/ G-53	.223 (5.56mm)	15x1
HK-94/ MP-5	9mm	9/16x24
US M1/M2 Carabine	30	9/16x24
FN-FAL US Match	308 (7.62)	9/16x24
FN-FAL Para/ SAR-48	308 (7.62)	9/16x24
FN Heavy Barrel	308 (7.62)	11/16x24
STEYER AUG	.223 (5.56)	13x1 LH
AKM/ AK-47	0.223	14x1 LH
AKM/ AK-47	7.62x39	14x1 LH
GALIL	308 (7.62)	13x1 RH
GALIL	.223 (5.56)	13x1 RH
UZI Carabine/ SMG	9mm	5/8x24
UZI Carabine	0.45	
M1A/ M-14	308	
L1-A1	308	9/16x24
MAS 1949-56	308	17x1